170

QC4- 100% Inspect kits for completeness



Quality Control

Memo

## Work Order ID 58476

May 7, 2010 10:24:52 AM



Page 2

Item ID:

D206-559-011

Accept



Setup Start

Stop



**Revision ID:** 

Item Name: Bearpaw

Start Date:

07/05/2010

OC:

Start Otv: 4.00

**Required Date: 14/05/2010** Rea'd Otv: 4.00



**Cust Item ID: Customer:** 

Draw

Number

Reference:

An	nro	vole.
AD	pro	vals:

Process Plan:

Date:

Date:

Tooling:

0.00

0.00

SPC (Y/N):

Set Up/

**Run Hours** 

Date:

Date:

Draw

Rev.

Plan

Code

Run Start

Reject

**Qty** 

Stop

Sequence ID/ Work Center ID

180

Packaging

Packaging

Description

Operation

Packaging

Identify and pack for shipping as per PPPD206-559-

011 □Location:

TRVB

190

QC **Quality Control** 

Memo

QC21- Final Inspection - Work Order Release

Accept

Oty

Reject

Insp. Number Stamp

0.00

0.00

	klist Print 7, 2010 `10:24:57 AM					Page 1
Paren Paren	IPP Rev:D (IPP Rev:E	08-05-05 up a chg DD	ed RJ/JLM JLM JLM JLM JLM JLM verified by:EC	••••••	Start Date: 07/05/2010 Start Qty: 4.00	Required Date: 14/05/2010 Required Qty: 4.00
Sed Bolt	15A . 	Purchased	No	160 Each	207.0000 <b>32</b>	
AN4-1		Purchased	Location ST358 114239 114292	Loc Oty 207 26 181 160 Each	982.0000 30x 8	m L 1406/11
AN960 Washer D2182i		NAS114900	Location ST359 No 4635	Loc Oty 982 982 160 Each MI145 160 f	0.0000 16 576  64x 371.9138 1.666 4:66	m/ 10/06/
Su	r Cushion  7  10  2B050) Cut (4) at 5.00" as per dwg	<i>(</i> ) \	Location ST402A 30872 ST410 52649	9.67 9.67 9.67 362.2438 362.2438	Loc Code	5 m.L 10/06/11

## **Picklist Print**

May 7, 2010 10:24:57 AM

Page 2

Work Order ID: 58476

Parent Item:

Comments:

D206-559-011

Parent Item Name:

Bearpaw

IPP Rev:E

IPP Rev:C□04.02.17□Blank size changed□KJ/JLM□ IPP Rev:D 07-01-02

Was K10007

IPP Rev:F

08-05-05 08-10-15 up a chg DD verified by:EC

New Manufacturing Method JLM Verified By:EC



Start Date: 07/05/2010

Required Date: 14/05/2010

Start Oty: 4.00

Required Oty: 4.00

32x m/h 12/06/11

D2274

Radius Block

Manufactured

Manufactured

Manufactured

Manufactured

No

No

No

160

Each

689.0000

Loc Code



Bearpaw, 206

D2438

Clamp

D2529

Location Loc Qty ST010 689 54850 66 56686 117 577143 233 57912 273

No

160

160

Each

Each

Each

0.0000

133.0000

Location Loc Qty ST456 133 55447 33 100

160

Loc Code

B58568 V

B59160

Location Loc Qty ST017 142 56184 142 Loc Code

## **Picklist Print**

May 7, 2010 10:24:57 AM

Page 3

Work Order ID: 58476

Parent Item:

Comments:

D206-559-011

Parent Item Name:

Bearpaw

IPP Rev:C□04.02.17□Blank size changed□KJ/JLM□

IPP Rev:D 07-01-02 IPP Rev:E

08-05-05 IPP Rev:F 08-10-15

Was K10007

up a chg DD verified by:EC New Manufacturing Method JLM Verified By:EC

Start Date: 07/05/2010

**Required Date: 14/05/2010** 

Start Qty: 4.00

Required Qty: 4.00

MS21042L4

Purchased

No

160

Each

2,408.000 32 8



Location		Loc Oty	Loc Code
ST139		2	
	111827	2	•
ST300		2098	
	113422	96	
	114523 🗸	1994	
	9063	8	
ST463		308	
	114416	308	

QS200-M44S

Purchased

No

160

Each

10.0000



Location ST450

Loc Qty 10

10

Loc Code

8x m/l 6/06/11

32x m-10/06/11

#### DART AEROSPACE LTD.

# REFERENCE ONLY



**D206-559** Page 7 of 13

#### 5.0 PARTS LIST

X	Qty	Qty	Qty	Qty	Qty	Qty	Qty	Part Number	Description
X	-011	-013	-021	-023	-031	-033	-113		
X   D206-559-021   Narrow Bearpaw Kit 206 A/B	X							D206-559-011	Bearpaw Kit 206 A/B
X   D206-559-023   Narrow Bearpaw Kit 206 L/L1/L3/L		Х						D206-559-013	Bearpaw Kit 206 L/L1/L3/L4/407
X			X					D206-559-021	Narrow Bearpaw Kit 206 A/B
X   D206-559-033   Wearplate Kit   X   D407-559-113   Large Bearpaw Kit 206 L/L1/L3/L4/L4   66				Х				D206-559-023	Narrow Bearpaw Kit 206 L/L1/L3/L4/407
X   D407-559-113   Large Bearpaw Kit 206 L/L1/L3/L4/   4   6	,				Х			D206-559-031	Wearplate Kit
4         6i         4         6           8         12         8         12         20         D2274         RADIUS BLOCK           2         D2435         19" X 16" BEARPAW         19" X 24" BEARPAW           2         D2671         13" X 16" BEARPAW           4         6         4         6         D2432F         19" X 24" BEARPAW           4         6         4         6         D2672F         13" X 24" BEARPAW           4         6         4         6         D2438         CLAMP           8         12         8         12         D2529         WASHER           6         6         7         D2732-050         RUBBER CUSHION         WASHER           2         D3456-1         WASHER         WASHER         WASHER           2         D3859-041         WEARPLATE         WEARPLATE           2         D3860-041         WEARPLATE         WEARPLATE           3         D4010-041         BEARPAW ASSEMBLY         BEARPAW ASSEMBLY           4         8         D4011-1         CLAMP, SHORT         CLAMP, SHORT           4         AN401-15         CLAMP, SHORT         CUSHION           5						Х		D206-559-033	Wearplate Kit
4							Х	D407-559-113	Large Bearpaw Kit 206 L/L1/L3/L4/407
8         12         8         12         20         D2274         RADIUS BLOCK           2         10         D2435         19" X 16" BEARPAW         19" X 24" BEARPAW         19" X 24" BEARPAW         19" X 24" BEARPAW         19" X 24" BEARPAW         10		6	4	6				D2182B050 J	RUBBER CUSHION
D2435							20		
D2432F	2				8 Au-				
D2671		2				· · ·		D2432F	
2			2					D2671	13" X 16" BEARPAW
4         6         4         6         D2438         CLAMP           8         12         8         12         D2529         WASHER           6         6         6         D2732-050         RUBBER CUSHION           2         D3456-1         WASHER           2         D3859-041         WEARPLATE           2         D3860-041         WEARPLATE           2         D4010-041         BEARPAW ASSEMBLY           2         D4011-1         CLAMP, SHORT           2         D4011-3         CLAMP, LONG           3         D4011-5         CLAMP, SHORT (OEM)           4         D4012-1         CUSHION           4         AN4C10A         BOLT           8         12         8         12           8         12         8         12           8         12         AN4-15A         BOLT           8         AN4C15A         BOLT				2				D2672F ,	
6 6 6 D2732-050 RUBBER CUSHION 2 D3456-1 WASHER 2 D3859-041 WEARPLATE 2 D4010-041 WEARPLATE 3 D4011-1 CLAMP, SHORT 4 D4012-1 CUSHION 5 D4012-1 CUSHION 6 D4012-1 CUSHION 7 D4012-1 CUSHION 7 D4012-1 CUSHION 8 D4011-5 BOLT 8 12 8 12 B 12 AN4-15A BOLT 8 12 8 12 B 12 AN4-17A BOLT 8 AN4C13A BOLT 8 AN4C15A BOLT	4	6	4			184		D2438	CLAMP
2 D3456-1 WASHER 2 D3859-041 WEARPLATE 2 D3860-041 WEARPLATE 3 D4010-041 BEARPAW ASSEMBLY 4 NA4C13A BOLT 4 AN4C13A BOLT 5 D3860-041 WEARPLATE 4 D4011-3 CLAMP, SHORT 5 CLAMP, LONG 6 CLAMP, SHORT (OEM) 7 CUSHION 8 D4012-1 CUSHION 8 D4012-1 CUSHION 8 D4012-1 CUSHION 8 D4012-1 CUSHION 9 D4012-1 CUSHION	8	12	8	12				D2529	WASHER
2   D3859-041   WEARPLATE     2   D3860-041   WEARPLATE     2   D4010-041   BEARPAW ASSEMBLY     8   D4011-1   CLAMP, SHORT     2   D4011-3   CLAMP, LONG     8   D4011-5   CLAMP, SHORT (OEM)     10   D4012-1   CUSHION     4   AN4C10A   CUSHION     8   12   8   12   AN4-15A   BOLT     8   12   8   12   AN4-17A   BOLT     8   AN4C13A   BOLT     8   AN4C15A   BOLT     8   BOLT     9   BOLT		6		6		,		D2732-050	RUBBER CUSHION
2 D3860-041 WEARPLATE 2 D4010-041 BEARPAW ASSEMBLY 8 D4011-1 CLAMP, SHORT 2 D4011-3 CLAMP, LONG 8 D4011-5 CLAMP, SHORT (OEM) 10 D4012-1 CUSHION 2 AN4C10A BOLT 8 12 8 12 8 12 AN4-15A BOLT 8 12 8 12 AN4-17A BOLT 8 AN4C13A BOLT 8 AN4C15A BOLT							2	D3456-1	WASHER
2 D4010-041 BEARPAW ASSEMBLY  8 D4011-1 CLAMP, SHORT  2 D4011-3 CLAMP, LONG  8 D4011-5 CLAMP, SHORT (OEM)  10 D4012-1 CUSHION  4 AN4C10A BOLT  8 12 8 12 8 12 AN4-15A BOLT  8 12 8 12 AN4-17A BOLT  4 AN4C13A BOLT  8 AN4C15A BOLT						2		D3859-041	WEARPLATE
8 D4011-1 CLAMP, SHORT   2 D4011-3 CLAMP, LONG   8 D4011-5 CLAMP, SHORT (OEM)   10 D4012-1 CUSHION   2 AN4C10A					2			D3860-041	WEARPLATE
2 D4011-3 CLAMP, LONG 8 D4011-5 CLAMP, SHORT (OEM) 10 D4012-1 CUSHION 2 AN4C10A , BOLT 8 12 8 12 AN4-15A BOLT 8 12 8 12 AN4-17A BOLT 1 AN4C13A BOLT 8 AN4C15A BOLT 8 AN4C15A BOLT							2	D4010-041	BEARPAW ASSEMBLY
8 D4011-5 CLAMP, SHORT (OEM) 10 D4012-1 CUSHION  2 AN4C10A , BOLT 8 12 8 12 AN4-15A BOLT 8 12 8 12 AN4-17A BOLT 4 AN4C13A BOLT 8 AN4C15A BOLT 8 AN4C15A BOLT							8	D4011-1	CLAMP, SHORT
10 D4012-1 CUSHION   2 AN4C10A							2	D4011-3	CLAMP, LONG
2 AN4C10A , BOLT 8 12 8 12 8 12 AN4-15A BOLT 8 12 8 12 AN4-17A BOLT 4 AN4C13A BOLT 8 AN4C13A BOLT 8 AN4C15A BOLT							8	D4011-5	CLAMP, SHORT (OEM)
8 12 8 12 8 12 AN4-15A BOLT 8 12 8 12 AN4-17A BOLT 4 AN4C13A BOLT 8 AN4C15A BOLT 8 AN4C15A BOLT							10	D4012-1	CUSHION
8     12     8     12     AN4-15A     BOLT       8     12     8     12     AN4-17A     BOLT       4     AN4C13A     BOLT       8     AN4C15A     BOLT							2	ANAC10A	BOLT
8 12 8 12 8 12 AN4-17A BOLT 4 AN4C13A BOLT 8 AN4C15A BOLT	R	112	Я	12	8	12	<del></del>		
4 AN4C13A BOLT 8 AN4C15A BOLT					1				
8 AN4C15A BOLT	<del></del>	112	<del>-</del>	'-		12	4		
		<del></del>			<b> </b>				
8 AN4C17A ↑ BOLT				<del> </del> -	<del> </del>		8	ANIAO47A	BOLT
16 24 16 24 AN960JD416 WASHER	16	24	16	24		·	ا ا		
8 12 8 12 8 12 MS21042L4 NUT (OR MS21042-4)					8	12			
20 MS21043-4 NUT				- <u>'-</u>	<u> </u>		20		
8 12 NAS1149D0463J WASHER				<del> </del>	8	12			
2 2 QS200M44S CLAMP	2		2		<u> </u>				

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Revision: K

Date: 09.11.16

## **Dart Aerospace Ltd**

W/O:			WO	RK ORDER CHANGI	ES				
DATE	STEP	PRO	OCEDURE CHAI	NGE	By Date Oty Chief Eng.				Approval QC Inspector
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		·				· · · · · · · · · · · · · · · · · · ·			
Part No	:	PAR #:	Fault Cated	iorv.	NCR: Vas	No <b>DO</b>	Δ-	Date:	
Part No: PAR #:				QA: N/C Closed: Date:					
NCR:				R NON-CONFORMA		_			
DATE	STEP	Description of NC	Corrective Action Section B			Verific	ation	Approval	Approval
DAIE	SIEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Secti		Chief Eng	QC Inspector
• •									

NOTE: Date & initial all entries